

Date: Thursday, 4/12/2007 8:40:21 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 SKIDTUBE ASSEMBLY RH
Job Number	: 31681		
Estimate Number	: 10268		
P.O. Number	: <i>NIA</i>	Part Number	: D350636014
This Issue	: 4/12/2007 S.O. No. : <i>NIA</i>	Drawing Number	: D2750 UNDER REVIEW <i>CB</i>
Prsht Rev.	: NC	Project Number	: N/A <i>07.04.12</i>
First Issue	: <i>NIA</i> Type : LANDING GEAR	Drawing Revision	: D
Previous Run	: 31680	Material	: <i>NIA</i>
Written By	:	Due Date	: 4/24/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>[Signature] 07.04.12</i>		
Comment	Est Rev:H 02.09.25 Rearranged procedure stepsKJ Est Rev:I 05.12.08 Rearranged procedure stepsEC Est Rev:J 06.03.30 Per rev. D EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-014 CHG 002

KS 07.04.16 ①

2.0	D26003BENT	Extrusion Bent
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-3-Bent	Extrusion (Bent)	<i>B 30666</i>

7-5-19

3.0	D2744	Fwd Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:	<i>329784</i>	<i>BE 07-05-22</i>
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4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8864 drilling holes labelled "B" only.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut

7-5-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Seq. #:

Machine Or Operation:

Description:

as per dwg D2750.

4-Drill pilot holes for Detail B using DT8330

5-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750.

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.250" ***Make sure that wearplate holes are on bottom of tube*****

7-Open up holes of Detail A to 0.250" (total of 2 holes per side)

8- Countersink all fwd wearshoe holes (total of 19 holes per side) DO NOT C'SINK THE LAST AFT HOLES (total of 2 per side for blade fitting) as per dwg D2750.

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *m/02421/m/03794 BE 07-05-22*

10-Grind welds flush as per Dwg D2750 *pm 07-05-22*

11-Countersink Detail A as per dwg D2750. *pm 07-05-22*

7-5-19

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-05-22

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP

7-5-22

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JP 7-5-22

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 07-05-23

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

Batch: *32289*

JP 7-5-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 31681

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D34901

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

~~Crossbolt spacer~~

Batch:

32045 (6P) BE 07-05-24

11.0

D34905

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch:

329796 BE 07-05-24

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch:

30448 BE 07-05-24

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes "size X" (total of 4 holes per side) as per dwg D2750

PM 07-05-23 (1)

2-Open up holes of Detail V & Detail C to 0.625" (total of 8 holes per side) as per dwg D2750.

PM 07-05-23 (1)

3-Chamfer holes of Detail V, Detail C, hole size "W" and "X" per dwg D2750 (welding instructions on sheet 5)

PM 07-05-23 (1)

4-Deburr and blow out all chips from inside of tube

PM 07-05-23 (1)

5-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch:

M 103561

exp. date:

7-10-1

6- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 5)

A/R

Aluminum Rod

batch:

M 103794 BE 07-05-24

7-Grind welds flush as per Dwg D2750

PM 07-05-28 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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Job Number: 31681

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

10-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750 *pm 07-05-280*

11-Deburr holes *pm 07-05-280*

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/05/29 (1)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-05-31

PIB

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

M 105068

PRESSURE WASH
07-08-01

BR/M 07-08-01

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

En 07/08/01

18.0

NAS1330S3KB166

INSERT



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

INSERT

Batch: *M103279*

07-08-01 (1)

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

07-08-02 (1)

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Inserts

En 07/08/02 (+1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/08/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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07-05-29	15.0	The 2 most fwd x-bolt holes are too low on one side causing a installation issue with the step.	Qs1042	Remove 2 x-bolt spacers & replace B#32045 PIN D3490-1 Position the x-bolt spacers 0.040" higher on the outside, tack. Test fit by QC.	BE 07-05-31	07-05-31	Qs1042	07-05-29
↓	↓	~ ↓ =	Qs1042	Weld x-bolt spacer AS per Qs1004 & Dwg.	BE 07-05-31		Qs1042	07-05-29
				grind weld flush and debur	pm 07-05-31	07-06-07	Qs1042	07-05-29

NOTE: Date & initial all entries

Process Sheet

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 31681

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Wearpad

Batch: B31695

JS

22.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B31695

B30553

JS

23.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B30554

JS

24.0

D2746

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B30141

JS

25.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: 2 batches

- B30557(X5)

- B31697(X3)

* JS

26.0

D3488042

BLADE FITTING ASSEMBLY, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: B30112

27.0

D3492041

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B32598

*

JS 07-08-02

D

W/O:		WORK ORDER CHANGES					
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Job Number: 31681

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D3492045

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 1330599

X AS

29.0

AN3C5A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Bolt

Batch: M104118

AS

30.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M103693

M

31.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M103668

AS

32.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M103894

AS

33.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M102671

AS

34.0

AN960C10L

washer



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

washer

Batch: M105057

AS

07-08-02

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Process Sheet

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 31681

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M104093

JH

36.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: M103693

37.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: M103492

JH

38.0

NAS1515H3L

WASHER



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

WASHER

Batch: M104603

JH

39.0

NAS1515H8L

WASHER



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

WASHER

Batch: M104922

JH

40.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Assemble tube hardware as per dwg D2750

sikaflex batch: M104989

2-Inspect For Foreign Objects ✓

3-Spray inside of tube with "LPS-3" batch: M105085

4-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH: M104989

JH

07-08-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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Job Number: 31681

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

EXP DATE: 08-01

5-Coat all exposed fasteners with "LPS Procyon" batch: 1104 251

04-08-02 ①

41.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/03

42.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

43.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: B30556

44.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M104093

45.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M104625

46.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M104117

07/08/03 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 31681

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description:

47.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: M1041260 -

48.0

D34931

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: B31706 -

49.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

50.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-014

51.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Jul 07-08-03



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART**RELEASED**
06.02.07**UNDER REVIEW**

07.04.05 CB

add gaskets
change to SS wearplates

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2750	REV. D SHEET 1 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS	
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133/9157	

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
5	5	5	5	D2648-3	WEARPAD
1	1	1	1	D2656-13	WEARSHOE
1	1	1	1	D2656-35	WEARSHOE
1	1	1	1	D2746	WEARSHOE
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
2	2	2	2	AN8C21A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
4	4	4	4	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
3	3	3	3	MS21083C8	NUT
42	42	42	42	NAS1330S3KB166	INSERT
46	46	46	46	NAS1515H3L	WASHER
12	12	12	12	NAS1515H8L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31681

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DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D2750	REV. D SHEET 2 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

UNDER REVIEW

07.02.05 CB

35 wearplates

OK
CB**RELEASED**
06.02.07 #**GENERAL NOTES:**

1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E, F-F, AND R-R.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL NAS1330S3KB166 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'E' SIZE HOLES ($\emptyset 0.250$ - $\emptyset 0.257$) FOR WEARSHOE INSERTS. C'SINK $\emptyset 0.391 \times 100^\circ$ AND INSTALL INSERTS
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3-5A/AN3-7A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12. APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES

SHOP COPY

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ENGINEERING

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WITHOUT NOTICE

MOCKUP

NO. 31681

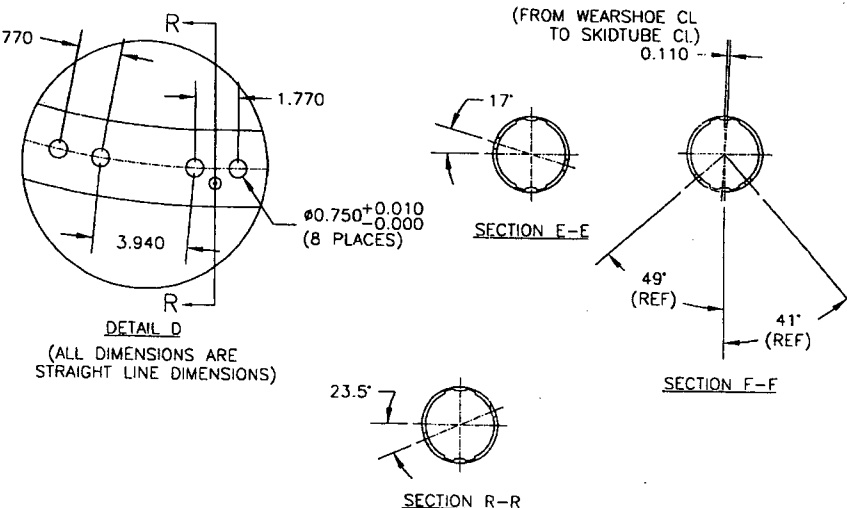
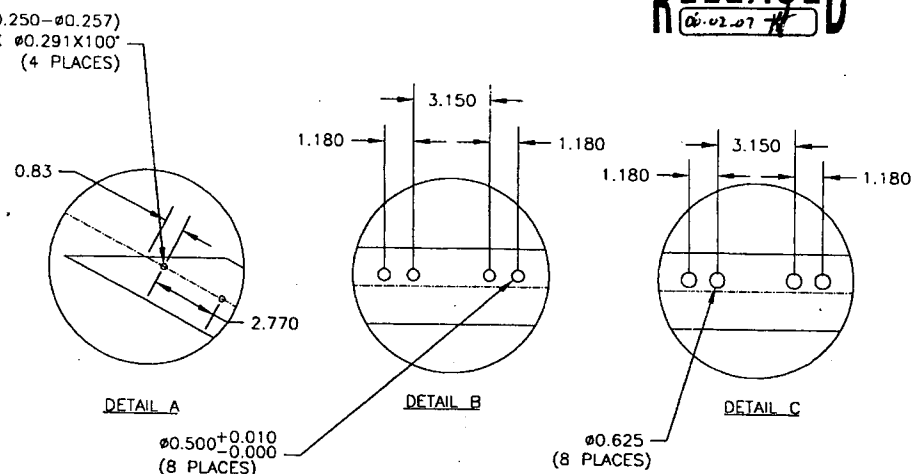
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ok
CB

~~SS wood-plates~~

RELEASE
06-02-07



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WORK ORDER
NO. 31681

	DRAWING NO.	REV. (
	D2750	SHEET 3 OF 5
	TITLE	SCALE
	360 SKIDTUBE ASSEMBLY	

SCALE

UNDER REVIEW

07.05 CB
54 wear plates
OK CB

INSTALL NAS1330S3KB166
INSERTS (4 PLACES)
AFTER FINISH

D2750-041/-042 ASSEMBLY
D2750-041 SHOWN (D2750-042 OPPOSITE)

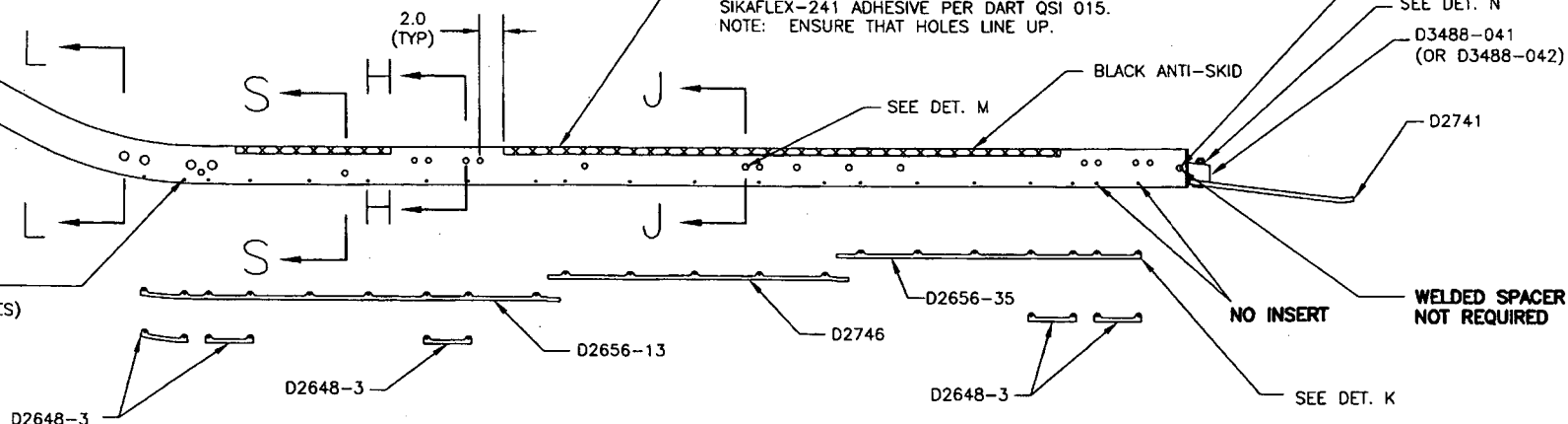
BOND D2739 WEB INTO D2750-1 (OR D2750-2)
OUTER TUBE WITH NON-STRUCTURAL
SIKAFLEX-241 ADHESIVE PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.

SEE DET. Q

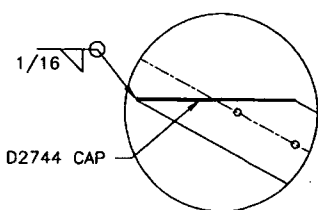
DETAIL G

INSTALL NAS1330S3KB166
WEARSHOE INSERTS (38 PLACES)
AFTER FINISH

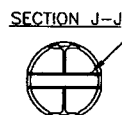
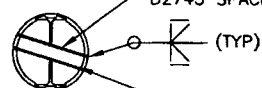
RELEASED
06.02.07 #



DETAIL G



SECTION H-H D2743 SPACER (REF)



WELDING INSTRUCTIONS

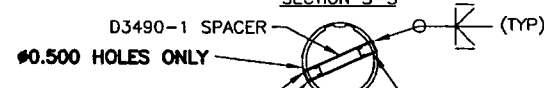
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

SECTION L-L



D3492-043 PLUG ASSEMBLY

SECTION S-S

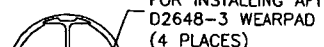


D3492-041 PLUG ASSEMBLY

WELDING INSTRUCTIONS

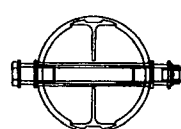
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES OR INSERT D3490-3 SPACER (4 PLACES) INTO Ø0.750 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER ON BOTH ENDS

DETAIL K



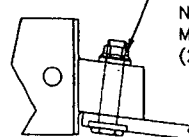
USE AN3C7A BOLTS
FOR INSTALLING AFT
D2648-3 WEARPAD
(4 PLACES)

DETAIL M



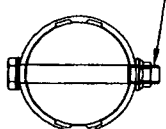
AN6-44A BOLT (1)
D2745 BUSHING (2)
NAS1515H8L WASHER (2)
MS21043-6 NUT (1)
(4 PLACES)
NOTE: INSTALL WASHER BETWEEN
SKIDTUBE AND BUSHING

DETAIL N



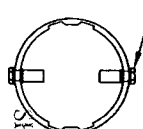
AN8C21A BOLT (1)
AN960JD816L WASHER (1)
NAS1515H8L WASHER (1)
MS21083C8 NUT (1)
(2 PLACES)

DETAIL P



AN3C5A BOLT (1)
AN960C816L WASHER (1)
NAS1515H3L WASHER (1)
(38 PLACES)

DETAIL Q



AN3C6A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(4 PLACES)

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DESIGN P4	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. 0
CHECKED #	APPROVED #	DRAWING NO. D2750	SHEET 4 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31681
ENGINEERING
RETURN TO
SHOP COPY

UNDER REVIEW

01.01.05 C6

OK C6

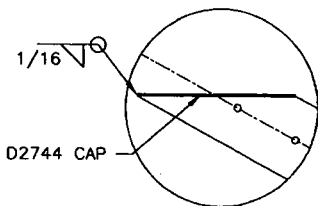
SEE DET. Q

DETAIL G

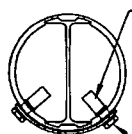
INSTALL NAS1330S3KB166
WEARSHOE INSERTS (38 PLACES)
AFTER FINISH

RELEASED
06.02.07.11

DETAIL G



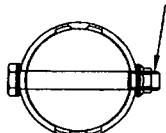
DETAIL K



USE AN3C7A BOLTS
FOR INSTALLING AFT
D2648-3 WEARPAD
(4 PLACES)

AN3C5A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(38 PLACES)

DETAIL P



AN8C35A BOLT (1)
AN960C816L WASHER (2)
NAS1515H8L WASHER (2)
MS21083C8 NUT (1)

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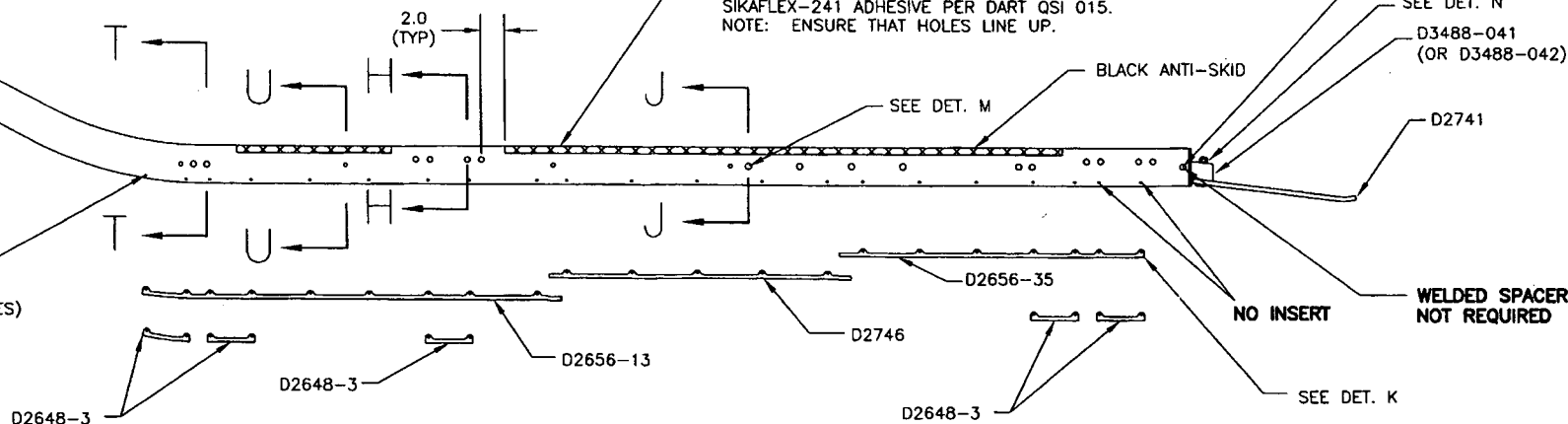
WORK ORDER

NO. 31681

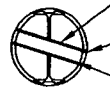
D2750-043/-044 ASSEMBLY
D2750-043 SHOWN (D2750-044 OPPOSITE)

INSTALL NAS1330S3KB166
INSERTS (4 PLACES)
AFTER FINISH

BOND D2739 WEB INTO D2750-3 (OR D2750-4)
OUTER TUBE WITH NON-STRUCTURAL
SIKAFLEX-241 ADHESIVE PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.

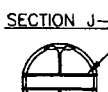


SECTION H-H



D2743 SPACER (REF)

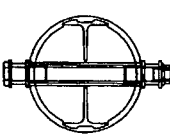
(TYP)



WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

DETAIL M



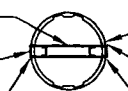
AN6C44A BOLT (1)
D2745 BUSHING (2)
NAS1515H8L WASHER (2)
MS21043-6 NUT (1)
(4 PLACES)
NOTE: INSTALL WASHER BETWEEN
SKIDTUBE AND BUSHING

DETAIL Q



AN3C6A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(4 PLACES)

SECTION T-T



D3490-1 SPACER

Ø0.500 HOLES ONLY

D3492-041 PLUG ASSEMBLY

SECTION U-U



D3490-5 SPACER

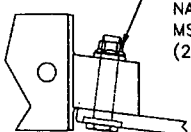
Ø0.313 HOLES ONLY

D3492-045 PLUG ASSEMBLY

WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-5 SPACER (4 PLACES) INTO Ø0.313 HOLES OR INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-045 PLUG ASSEMBLY (8 PLACES) INTO D3490-5 SPACER OR INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER ON BOTH ENDS

DETAIL N



AN8C21A BOLT (1)
AN960JD816L WASHER (1)
NAS1515H8L WASHER (1)
MS21083C8 NUT (1)
(2 PLACES)

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DESIGN	PH
CHECKED	#
DATE	06.01.05

DRAWN BY	PH
APPROVED	#
DRAWING NO.	D2750
TITLE	350 SKIDTUBE ASSEMBLY

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

REV. D
SHEET 5 OF 5
SCALE
1:20

NO. 109

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number A350636014 / B31622

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/05/23

Qualifier David Newell

CUSTOMER RETURN

#R08-041

Initiator: Jason Kerr
 Company: GCTPA (HANGAR LLC)
CGC1001
 Phone No: 262-798-5080

Date: April 25/08
 Invoice # 6364
 Order Entry # 5904

Reason for return: Customer wanted the SS wearplates
PAR 08-000 Attach Copy of DHS Return Authorization # 404

REFERENCE ONLY

Receiving: 2
 Date Received: 8/5/10 Freight Company: MINIMAX Prepaid Collect

#	Part #	Batch #	Description	Distribute to QC	
1	D350-636-013	32528	Skid tube LH	Advise QA	Date:
1	D350-636-014	31681	Skid tube RH	<u>DATE</u>	<u>8/5/10</u>

Condition of packaging: GOOD Photograph required: yes ☒ no

Paperwork attached: P/S ☒ Invoice ☐ ARC ☐ Docs ☐ Other ☐

QC:

Quarantine: Location: Condition of Part: good

Inspect: Initial:

#	Part #	Batch #	QC Comments	QC Approval	W/O #	Scrap
1	D350-636-013	832528	re-worked per DSI 9413 Rev A.	<u> </u>	<u>39347</u>	
1	D350-636-014	B31681		<u> </u>	<u>39349</u>	

QA Coordinator:

Advise GM as to findings: Initial: Date:

Comments:

NO charge
already sent

Issue credit: yes ☒ no

GM Approval: Date:

Invoice Amount:
 Less Replacement:
 Restock Fee:
 Freight:
 Net Credit:
 DHS ☐ Customer ☐

QA: Enter into Q-Pulse with reason for return & File original.

Signed: Date:

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit

Date:
User:Thursday, 4/12/2007 8:40:21 AM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 SKIDTUBE ASSEMBLY RH
Job Number	: 31681		
Estimate Number	: 10268		
P.O. Number	: <i>NIA</i>	Part Number	: D350636014
This Issue	: 4/12/2007 S.O. No. : <i>NIA</i>	Drawing Number	: D2750 UNDER REVIEW <i>CB</i>
Prsht Rev.	: NC	Project Number	: N/A <i>07.04.12</i>
First Issue	: <i>NIA</i> Type : LANDING GEAR	Drawing Revision	: D
Previous Run	: 31680	Material	: <i>NIA</i>
Written By	: <i>JA 07.04.12</i>	Due Date	: 4/24/2007
Checked & Approved By	: <i>JA 07.04.12</i>	Qty:	1 Um: Each
Comment	Est Rev: H 02.09.25 Rearranged procedure steps KJ Est Rev: I 05.12.08 Rearranged procedure steps EC Est Rev: J 06.03.30 Per rev. D EC		

Additional Product

REFERENCE ONLY

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-014 CHG 002

KS 07.04.16 ①

2.0

D26003BENT

Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1

D2600-3-Bent

Extrusion (Bent)

B

30666

7-5-19

3.0

D2744

Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch:

329784
BE 07-05-22

4.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2- Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8864 drilling holes labelled "B" only.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut

7-5-19

Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Number: 31681

Part Number: D350636014

Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Wearpad

Batch: B31695

HL

22.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B31695

B30553

HL

23.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B30554

HL

24.0

D2746

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B30141

HL

25.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: 2 batches

B30557(X5)

B31697(X3)

** HL*

26.0

D3488042

BLADE FITTING ASSEMBLY, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: B30112

27.0

D3492041

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B32598

HL 07-08-02

0

Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Order Number: 31681

Part Number: D350636014

Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D3492045

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 1330599

X M

29.0

AN3C5A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Bolt

Batch: M104118

M

30.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M103693

M

31.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M103668

M

32.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M103884

M

33.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M102671

M

34.0

AN960C10L

washer



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

washer

Batch: M105057

M

07-08-02

0

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 31681

Part Number: D350636014

Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M104093

JH

36.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: M103693

37.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: M103492

JH

38.0

NAS1515H3L

WASHER



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

WASHER

Batch: M104603

JH

39.0

NAS1515H8L

WASHER



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

WASHER

Batch: M104922

JH

40.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Assemble tube hardware as per dwg D2750

sikaflex batch: M104989

2-Inspect For Foreign Objects

✓

3-Spray inside of tube with "LPS-3"

batch: M105085

4-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH: M104989

JH

04-08-02

Thursday, 4/12/2007 8:40:21 AM
Jim Johnston

Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 31681

Part Number: D350636014

Number:



Seq. #:

Machine Or Operation:

Description:

EXP DATE: 08-01

5-Coat all exposed fasteners with "LPS Procyon" batch: M004 251

04-08-02 ①

41.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/03

42.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

43.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Blade
Batch: B30556

07/08/03

44.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Washer
Batch: M104093

07/08/03

45.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Nut
Batch: M104625

07/08/03

46.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bolt
Batch: M104117

07/08/03

07/08/03 ②

Thursday, 4/12/2007 8:40:21 AM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 31681

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description:

47.0

NAS1515H8L

WASHER



Comment: Qty: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: M104260 -

JP

48.0

D34931

WASHER



Comment: Qty: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: B31706 -

JP

JP 07/08/03

49.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

JP 07/08/03

50.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-014

REV E 6/18/03 O.S.P

51.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JP 07/08/03

Job Completion



JP 07-08-03

B31681